

Date: Monday, 5/15/2006 11:11:55 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 27110		
Estimate Number	: 10608		
P.O. Number	: N/A	Part Number	: D2655
This Issue	: 5/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2655 REV B
First Issue	: 5/15/2006	Project Number	: N/A
Previous Run	: 25145	Drawing Revision	: B
Written By	:	Material	: N/A
Checked & Approved By	: <u>06.05.15 W</u>	Due Date	: 5/30/2006
Comment	Qty: <u>40</u> Um: Each Est. D 00.06.22 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1263206/05/16 (40)

Laser Cut per D2655

Material release note required

2.0	D2655F	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Ring

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

4/10/25 (40)

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

N.A. 28 06/05/31 (40)

2-Deburr any rough edges after tumbling

M.F. 06/05/31 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes  No DQA: 

Date: 06/06/09

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date:  
User:

Monday, 5/15/2006 11:11:55 AM  
Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 27110

Part Number: D2655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Job 06-06-05



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

DC 06/06/05

(40)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Rec'd 6/15 (40)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST140

Rec'd 6/19 (40)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/06/05 (40)

Job Completion



Job 06-06-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

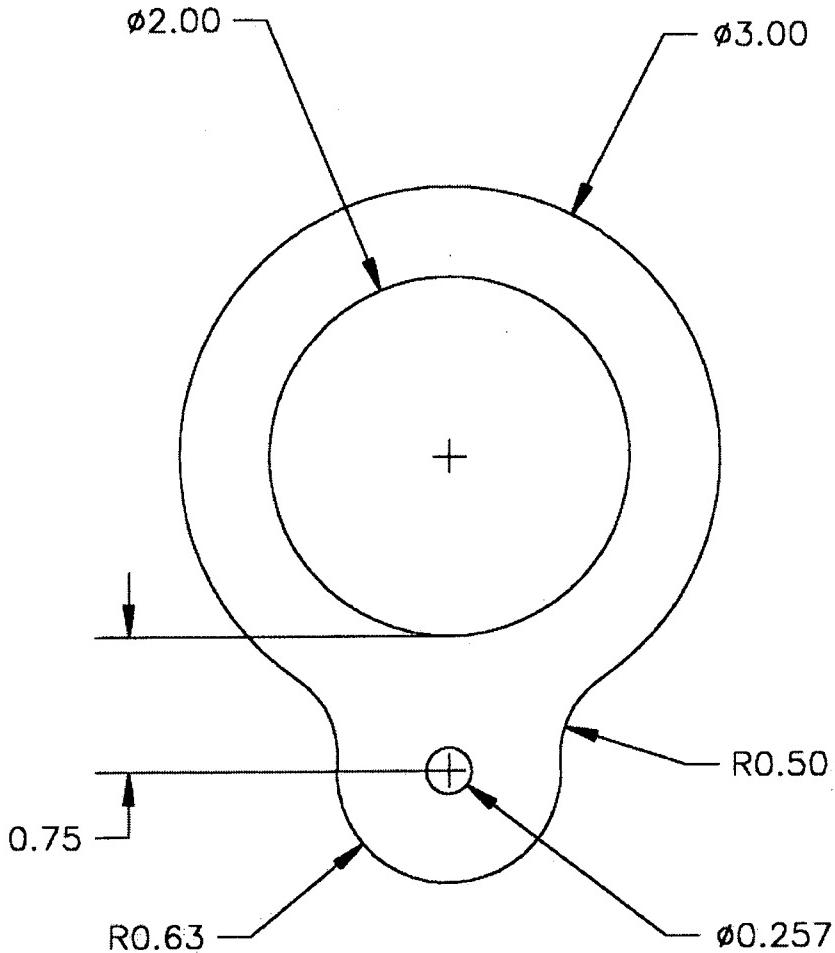
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN 0102	DRAWN BY 0102	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>SJ</i>	APPROVED <i>SA</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07	TITLE RING		SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

**RELEASED**  
[ 97/07/07 ] DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27110

NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK

FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**CAMBRIDGE STEEL MILL  
160 ORION PLACE  
CAMBRIDGE ON N1T 1R9 CAN  
(519) 740-2488**

## **Chemical and Physical Test Report**

MADE IN CANADA

N-037136

SHIP TO VEDDER TRANSPORT C/O WILKINSON STEEL AND METALS 588 RIVERSIDE ROAD ABBOTSFORD, BC	INVOICE TO WILKINSON STEEL & METALS VAN PREMETALCO INC 888 SOUTHEAST MARINE DR. VANCOUVER, BC V6X 2V3	SHIP DATE 01/12/06  CUST. ACCOUNT NO 60073699
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SHAPE + SIZE A2 X 2 X 14	GRADE 44W	SPECIFICATION CSA-G40.21-100W-98(44W); ASTM A36/A36M-04										SALES ORDER 5113667-03		CUST P.O. NUMBER P51121MV001				
		Mn	P	S	Si	Cu	Ni	Cr	Mo	V	NB	B	Sn	Al	Zr	C Eqv		
N545178	.16	.68	.003	.034	.15	.26	.12	.14	.050	.004	.000	.0000	.017	.001	.002	.366		

Mechanical Test: Yield: 50258 PSI, 346.52 MPa Tensile: 74435 PSI, 513.21 MPa %E: 27.05%, 27.0200MM Red R: 26.7 : 1

Tensile: 74737 PSI, 515.29 MPa      KEL: 27.0/Bin, 27.0Z/200MM      Rod R: 26.7 ± 1

SHAPE + SIZE		SPECIFICATION											SALES ORDER		CUST P.O. NUMBER				
A2 X 2 1/4		44W CSA (40-21-300W-98(44W); ASTM A36/A36M 04											S113597-03		P51121MV601				
HEAT ID.	C	Mn	P	S	Si	Cu	Hi	C <sub>g</sub>	Mo	V	Nb	B	Sn	Al	Zr	C Eqv			
NS45180	.15	.63	.011	.034	.18	.27	.09	.16	.043	.004	.001	.0000	.019	.001	.032	.325			

Mechanical Test: Yield 48109 PSI, 331.7 MPa Tensile: 70847 PSI, 488.47 MPa El.: 28.54Hv, 28.5200MM Red R: 26.7

**Mechanical Test** Yield: 400.08 Psi: 331.55 MPa Tensile: 710.75 Psi: 490.04 MPa El: 28.0/6in. 28.0/200MM Red R: 26.7

Mechanical Test: Yield 60567 PSI / 418.65 MPa Tensile: 73436 PSI / 500.32 MPa屈服: 27.08kN, 22.02kN/mm, - Red R 26.7 1

Mechanical Test: Yield Yield Tensile: 73611 PSI, 507.53 MPa %Elongation: 27.08%, 27.0200MM Red R: 26.7 : 1

The material, including the labels, was produced and manufactured in Canada.

A.J. Turner  
Quality Assurance Manager  
Mitsubishi Electric  
Group

THE ABOVE FIGURES ARE CERTIFIED EXTRACTS FROM THE ORIGINAL CHEMICAL AND PHYSICAL TEST RECORDS AS CONTAINED IN THE PERMANENT RECORDS OF COMPANY.

Mgr. Metallurg. Svcs.  
CAMBRIDGE STEEL, INC.

P510BPC002

## MILL TEST CERTIFICATE

ORIGINAL

872

YIEH MAU CORP.

P.03

SBS 755 1320

INVOICE NO.: F03MA29

COMMODITY: PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION: AISI 304

CUSTOMER: OLBERT METAL SALES LIMITED

地址: 高雄縣旗津鄉旗津路345號  
 345, SHUN AN RD., LU-CHU, LIAO-  
 KAOHSIUNG, TAIWAN, R.O.C.  
 TEL: (07) 657-2285 FAX: (07) 657-3006  
 CERTIFICATE NO: F03MA29  
 DATE OF ISSUE: 11/03/2005

16GA 304 SS.

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties					Chemical Composition (%)							
		KGS	lbs			Tensile Test GL=50 mm					C x100	Si x100	Mo x100	P x1000	S x1000	Ni x100	Cr x100	N x100
<b>AISI 304 NO.4 (FLAT ON MAIN SIDE WITH BACK PASS)</b>																		
16GA / 48" X 96"	1	1,476	3,254	YU236038	4AS16493A-32	297	659	51	79	149	4.3	46	105	33	12	805	1818	2.9
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-21	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-22	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 120"	1	1,630	3,373	YU236038	4AS16494A-11	315	675	51	80	155	4.3	48	105	32	12	806	1818	2.9
16GA / 48" X 120"	1	1,636	3,384	YU236038	4AS16494A-12	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,639	3,391	YU236038	4AS16494A-13	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,640	3,395	YU236038	4AS16494A-14	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-15	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-16	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-17	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-18	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-19	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-20	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-21	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-22	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-23	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-24	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-25	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-26	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-27	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-28	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-29	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-30	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-31	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-32	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-33	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-34	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-35	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-36	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-37	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-38	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-39	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-40	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-41	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-42	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-43	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-44	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-45	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-46	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-47	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-48	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-49	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-50	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-51	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-52	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-53	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-54	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-55	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-56	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-57	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-58	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-59	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-60	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A-61	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	2	1,641	3,397	YU236038	4AS16494A													

